



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D2530**

**Job Sheet 168867**



**Part No:** D2530

**Job Qty:** 8 ea

**Part Name:** Handle Weldment



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 11/23/17

**Job Tracking No:**

**Due Date:** 12/3/17

**Created By:** Linda Lacelle

**Type:** SOLD

**Description:**

**Note:** DWG REV B IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F 11.01.07 chg qc 5 to 6 DD verf:EC

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off        |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                 |
| 90    | Start up Operation | 8 Ea  | 12/2/17    | 12/2/17  | 0.00      | 0.00    | Start Up Small Fab    |           | MCL             |
| 100   | Small Fab          | 8 pcs | 12/2/17    | 12/2/17  | 0.12      | 1.55    | Small Fab             |           | MCL DAS 38      |
| 110   | QC                 | 8 pcs | 12/2/17    | 12/2/17  | 0.00      | 0.00    | QC5                   |           | 38              |
| 120   | Large Fab          | 8 pcs | 12/2/17    | 12/2/17  | 0.00      | 3.20    | Large Fab 1           |           | DYC 18/01/18 38 |
| 130   | QC                 | 8 pcs | 12/2/17    | 12/2/17  | 0.00      | 0.00    | QC9                   |           | 38              |
| 140   | QC                 | 8 pcs | 12/2/17    | 12/2/17  | 0.00      | 0.00    | QC5                   |           | 38              |
| 150   | Powdercoat         | 8 pcs | 12/3/17    | 12/3/17  | 0.00      | 0.30    | Powdercoat4           |           | BL 18/01/18 38  |
| 160   | QC                 | 8 pcs | 12/3/17    | 12/3/17  | 0.00      | 0.00    | QC3                   |           | 38              |
| 170   | Packaging          | 8 pcs | 12/3/17    | 12/3/17  | 0.00      | 0.00    | Packaging3            | 5-1329    | AC 38 18/01/18  |
| 180   | QC21-SA            | 8 Ea  | 12/3/17    | 12/3/17  | 0.00      | 0.00    | QC21                  |           | 38              |

Part Op 100 - 1-Cut to length as per Dwg D2530

Descriptions: 120 - 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

150 - START TIME: 11:20 FINISH TIME: 11:58 O.T. 320° M 13548

### Job Allocations

| Operation             | Component Part          | Required | Inventory | Allocated | Std Qty |
|-----------------------|-------------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | M304TR0.750W.049 501137 | 23       | 58        | 0         | 0       |
| 120-Large Fab         | D2534                   | 16       | 12        | 0         | 0       |

### Part Specifications

Specifications could not be found.

Plex 11/23/17 3:04 PM dart.lacelle.linda

**DART**  
AEROSPACE  
**S020184**

**Dart Aerospace Ltd.**

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CANADA

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**Handle Weldment**

**PART NO: D2530**

**Revision:**

**Operation: Start up Operation**

**Change No:**

**Mfg Date: 12/12/17**

**Job No: 168867**

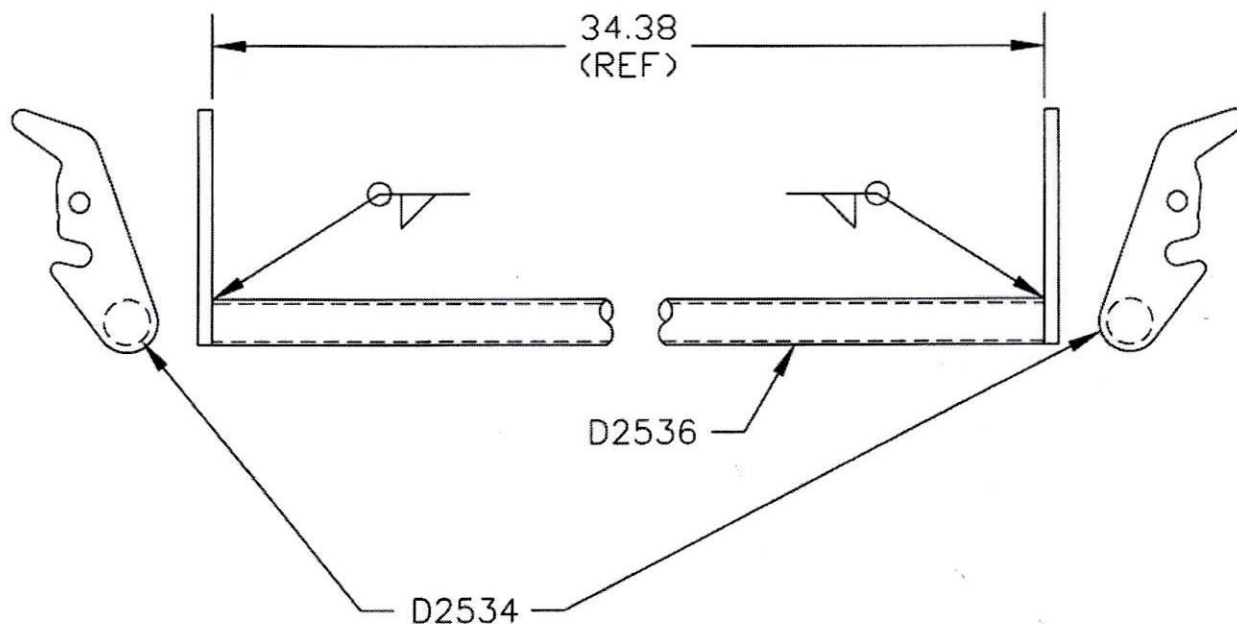


|                            |                             |                                        |              |
|----------------------------|-----------------------------|----------------------------------------|--------------|
| DESIGN                     | DRAWN BY                    | DART AEROSPACE LTD                     |              |
| B WILLIAMS                 | PH                          | VICTORIA INTERNATIONAL AIRPORT, CANADA |              |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO.                            | REV. B       |
|                            |                             | D2530                                  | SHEET 1 OF 1 |
| DATE                       | TITLE                       |                                        | SCALE        |
| 04.12.14                   | HANDLE WELDMENT             |                                        |              |
| A                          | 96.06.18                    | NEW ISSUE                              |              |
| B                          | 04.12.14                    | UPDATE NOTES AND DIMENSIONS            |              |

RELEASED  
04.12.16 *[Signature]*

### PART LIST -- D2530

| QTY | PART NUMBER | DESCRIPTION     |
|-----|-------------|-----------------|
| X   | D2530       | HANDLE WELDMENT |
|     |             |                 |
| 1   | D2536       | HANDLE          |
| 2   | D2534       | LOCK PLATE      |



#### D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOOT COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 168867



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Step #:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | MRB (QSI042) Approval                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Lead hand / Supervisor Approval Verification                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |